

Series 255M, 855M

.1181" - .5000"
(3.000mm - 12.700mm)

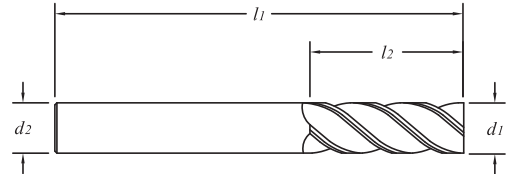


TOLERANCES	
d_1	+0.000" - .002" (+.000 - .050mm)
d_2	h6

Recommended for steels, stainless steel, and exotics

Square End

- Solid submicron grain carbide end mill - center cutting
- High performance milling
- Rigid work holding, machine stability and part integrity are critical!
- Improved finishes in titanium
- Heavy core
- Sharp corners
- AlTiN Coating - page 184
- TiCN Coated - page 188



MATERIAL HARDNESS (Rc)

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EDP#	d_1 † Diameter		d_2 Shank Diameter	l_1 Overall Length	l_2 Flute Length	1-11	12-24	25-49	50-100	
	Decimal	Metric								
40040	.1181	3.000	3.0	38	8	12.09	11.56	11.04	10.51	
40050	.1181	3.000	3.0	50	12	14.57	13.94	13.30	12.67	
52080	.1250	1/8"	3.175	1/8"	1-1/2"	1/4"	11.35	10.86	10.36	9.87
52090	.1250	1/8"	3.175	1/8"	2"	1/2"	13.67	13.08	12.48	11.89
40080	.1575	4.000	6.0	50	8	19.65	18.80	17.94	17.09	
40090	.1575	4.000	6.0	50	12	19.65	18.80	17.94	17.09	
52100	.1875	3/16"	4.763	3/16"	2"	5/16"	13.37	12.79	12.21	11.63
52120	.1875	3/16"	4.763	3/16"	2"	9/16"	13.37	12.79	12.21	11.63
40100	.1969	5.000	5.0	50	8	14.86	14.21	13.57	12.92	
40120	.1969	5.000	5.0	50	14	14.86	14.21	13.57	12.92	
40200	.2362	6.000	6.0	50	10	15.76	15.07	14.39	13.70	
40220	.2362	6.000	6.0	65	20	16.93	16.19	15.46	14.72	
40240	.2362	6.000	6.0	100	32	30.68	29.35	28.01	26.68	
52200	.2500	1/4"	6.350	1/4"	2"	3/8"	14.93	14.28	13.63	12.98
52220	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	16.13	15.43	14.73	14.03
52240	.2500	1/4"	6.350	1/4"	4"	1-1/4"	29.14	27.87	26.61	25.34
52300	.3125	5/16"	7.938	5/16"	2"	7/16"	20.41	19.53	18.64	17.75
52320	.3125	5/16"	7.938	5/16"	2-1/2"	13/16"	22.63	21.65	20.66	19.68
52340	.3125	5/16"	7.938	5/16"	4"	1-1/4"	38.01	36.36	34.70	33.05
40320	.3150	8.000	8.0	65	21	23.76	22.73	21.69	20.66	
40340	.3150	8.000	8.0	100	32	40.03	38.29	36.55	34.81	
52400	.3750	3/8"	9.525	3/8"	2"	1/2"	25.22	24.12	23.03	21.93
52420	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	28.18	26.95	25.73	24.50
52440	.3750	3/8"	9.525	3/8"	3-1/2"	1-1/2"	42.10	40.27	38.44	36.61
40420	.3937	10.000	10.0	70	22	34.30	32.81	31.32	29.83	
40440	.3937	10.000	10.0	88	38	52.41	50.13	47.85	45.57	
52500	.4375	7/16"	11.113	7/16"	2-1/2"	9/16"	34.40	32.90	31.41	29.91
52520	.4375	7/16"	11.113	7/16"	2-3/4"	1"	34.40	32.90	31.41	29.91
52540	.4375	7/16"	11.113	7/16"	4"	2"	57.93	55.41	52.89	50.37
40520	.4724	12.000	12.0	75	32	47.40	45.34	43.28	41.22	
40540	.4724	12.000	12.0	100	50	65.30	62.46	59.62	56.78	
52600	.5000	1/2"	12.700	1/2"	2-1/2"	5/8"	41.63	39.82	38.01	36.20
52620	.5000	1/2"	12.700	1/2"	3"	1-1/4"	45.14	43.18	41.21	39.25
52640	.5000	1/2"	12.700	1/2"	4"	2"	61.61	58.93	56.25	53.57

EDP#	d_1 † Diameter		d_2 Shank Diameter	l_1 Overall Length	l_2 Flute Length	1-11	12-24	25-49	50-100	
	Decimal	Metric								
52700	.6250	5/8"	15.875	5/8"	3"	3/4"	79.60	76.14	72.68	69.22
52720	.6250	5/8"	15.875	5/8"	3-1/2"	1-5/8"	87.04	83.26	79.47	75.69
52740	.6250	5/8"	15.875	5/8"	6"	2-1/2"	126.98	121.46	115.94	110.42
40600	.6299		16.000	16.0	75	20	83.78	80.14	76.49	72.85
40620	.6299		16.000	16.0	88	41	91.39	87.42	83.44	79.47
40640	.6299		16.000	16.0	150	63	126.98	121.46	115.94	110.42
52800	.7500	3/4"	19.050	3/4"	3"	7/8"	114.47	109.49	104.52	99.54
52820	.7500	3/4"	19.050	3/4"	4"	1-5/8"	127.63	122.08	116.53	110.98
52830	.7500	3/4"	19.050	3/4"	5"	2"	172.76	165.25	157.74	150.23
52840	.7500	3/4"	19.050	3/4"	6"	3-1/4"	202.29	193.49	184.70	175.90
40700	.7874		20.000	20.0	75	22	155.25	148.50	141.75	135.00
40720	.7874		20.000	20.0	100	41	170.38	162.98	155.57	148.16
40740	.7874		20.000	20.0	150	82	213.10	203.83	194.57	185.30
40780	.9843		25.000	25.0	100	28	197.94	189.33	180.73	172.12
40820	.9843		25.000	25.0	100	50	197.94	189.33	180.73	172.12
40840	.9843		25.000	25.0	150	82	328.37	314.09	299.82	285.54
52890	1.000	1"	25.400	1"	4"	1-1/8"	190.90	182.60	174.30	166.00
52920	1.000	1"	25.400	1"	4"	2"	190.90	182.60	174.30	166.00
52940	1.000	1"	25.400	1"	6"	3-1/4"	343.91	328.96	314.00	299.05



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MATERIAL HARDNESS (Rc)

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